

Date: Thursday, 18/12/2008 12:51:58 PM
User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SEAT RAIL ASSEMBLY	
Job Number :	44178			
Estimate Number :	13534			
P.O. Number :		Part Number :	D3808041	
This Issue :	18/12/2008	S.O. No. :	7	
Prsht Rev. :	NC	Drawing Number :	D3808 REV A	
First Issue :	18/12/2008	Project Number :	N/A	
Previous Run :	44098	Drawing Revision :	A	
		Material :		
Written By :		Due Date :	15/01/2009	Qty: 4 Um: Each
Checked & Approved By :	JLD 08.12.19			
Comment :	Est Rev:A New Issue 08-07-31 JLM Verified By:DD			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D38081	Seat Rail
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Seat Rail

BATCH: 44101

2.0	D38101	Hand Retractable Spring Plunger
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hand Retractable Spring Plunger

BATCH: 34077403. (B344260 x1) * SS 09/01/06 @

3.0	MS21209C610	Heli Coil, screw locking, red
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Heli Coil, screw locking, red

BATCH: M108847 SS 08/12/22 @

4.0	MS21209C0815	Heli Coil, screw locking, red
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Heli Coil, screw locking, red

BATCH: M108847 x12. M110440 4x SS 08/12/22 @

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Plunger as per Dwg D3808.

2-Install helicoils x5 as per Dwg D3808.

SS 09/01/12 (4)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/12	5.0	2 D38101 seizing up last ones of Batch # B40774 RC Series are not function according to spec		Destroyed Sogdud14		FF 09/01/12		
		→ Applied light oil and spring work.						

NOTE: Date & initial all entries

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Drawing Name: SEAT RAIL ASSEMBLY

Job Number: 44178

Part Number: D3808041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/14 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: 255

9/1/14

4x

SD

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/15

Job Completion



MF 09-01-15

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

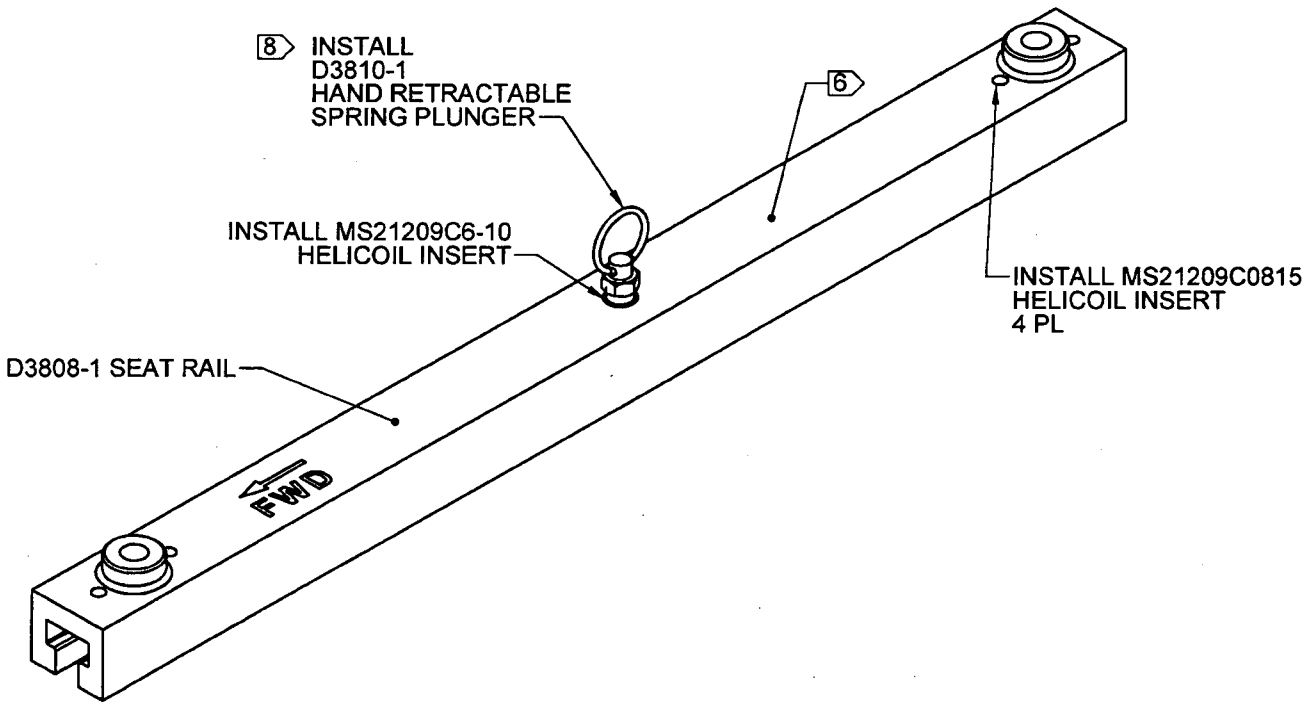
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

QTY -041	P/N	DESCRIPTION
X	D3808-041	SEAT RAIL ASSY
1	D3808-1	SEAT RAIL
1	D3810-1	HAND RETRACTABLE SPRING PLUNGER
1	MS21209C6-10	HELI-COIL, SCREW LOCKING (RED)
4	MS21209C0815	HELI-COIL, SCREW LOCKING (RED)



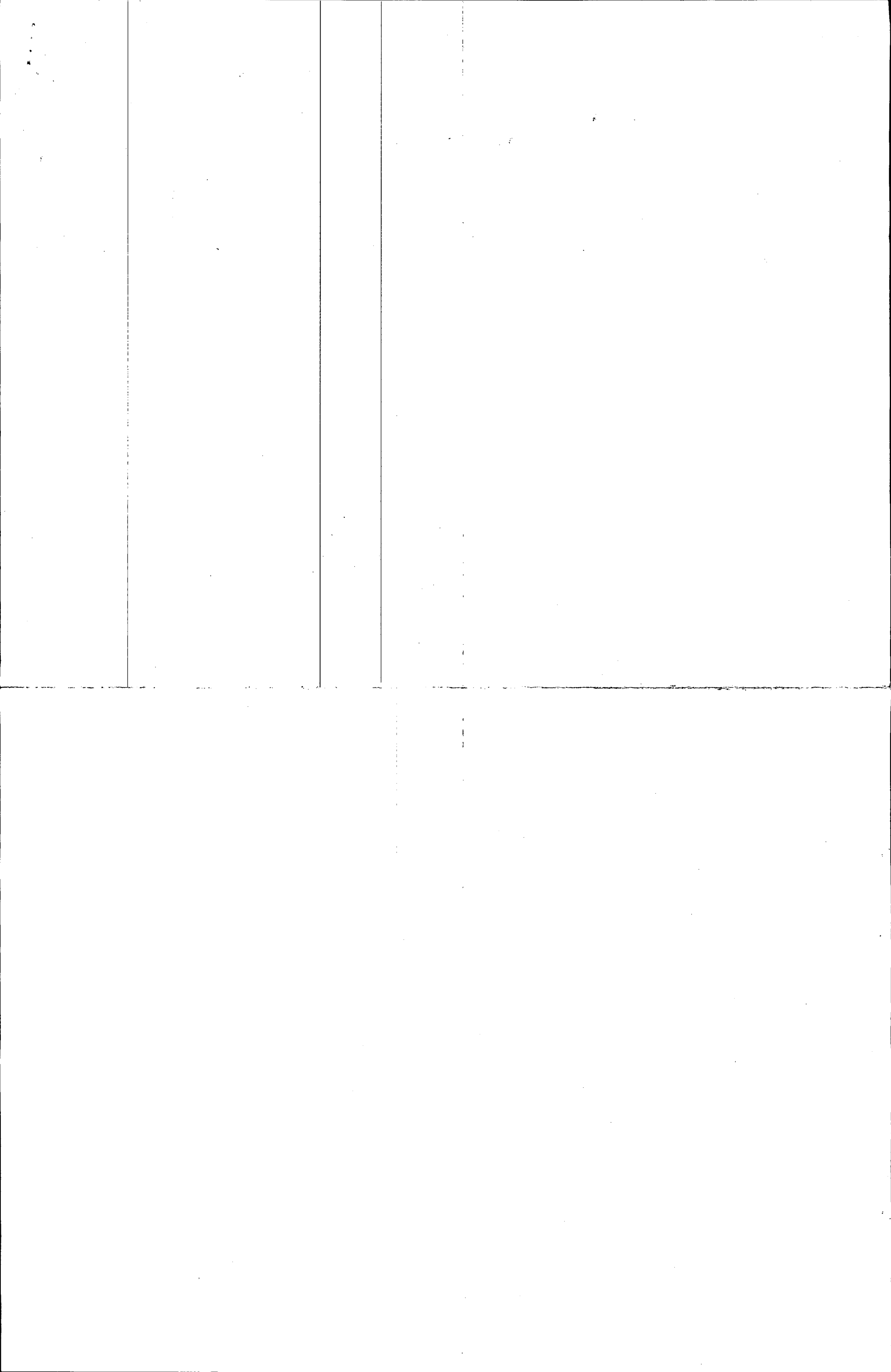
D3808-041 SEAT RAIL ASSEMBLY

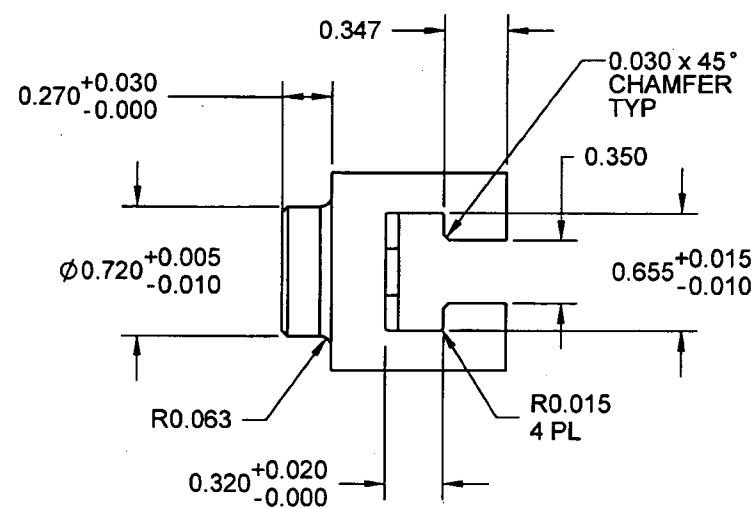
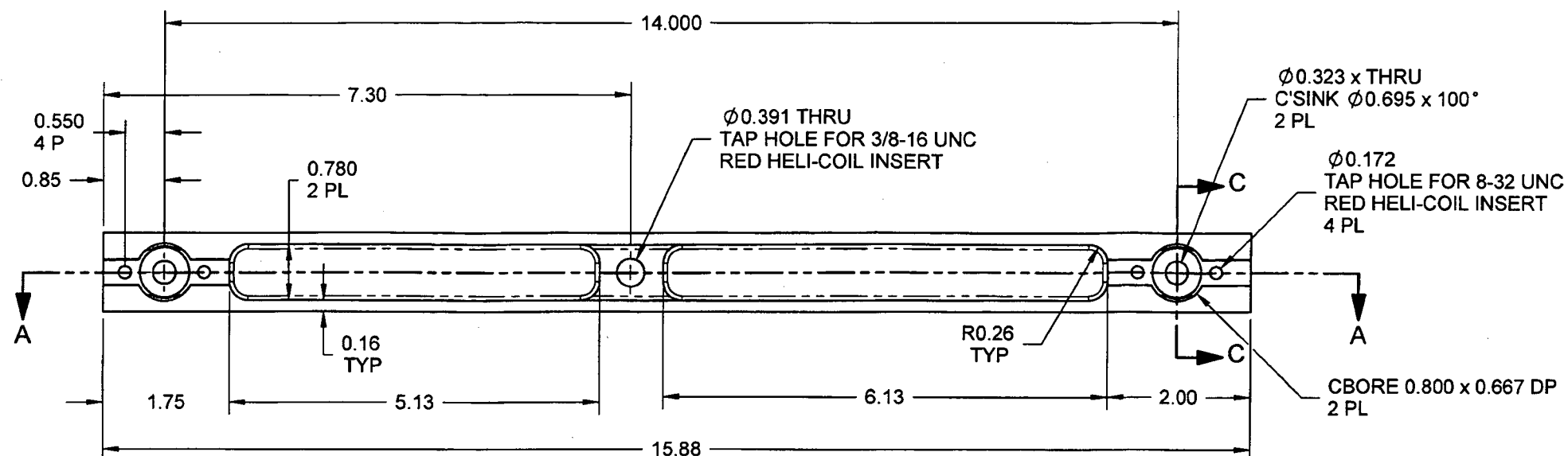
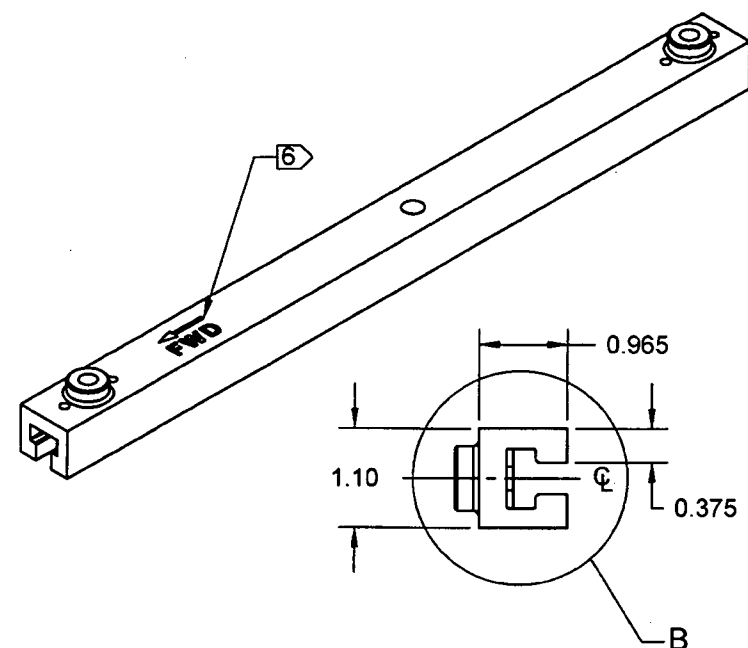
D3808-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3808-041 USING FINE POINT PERMANENT INK MARKER AS SHOWN
- 7) WEIGHT: 0.80 lbs
- 8) INSTALL D3810-1 INTO D3808-1 ONLY UNTIL NO THREADS VISIBLE ON D3810-1

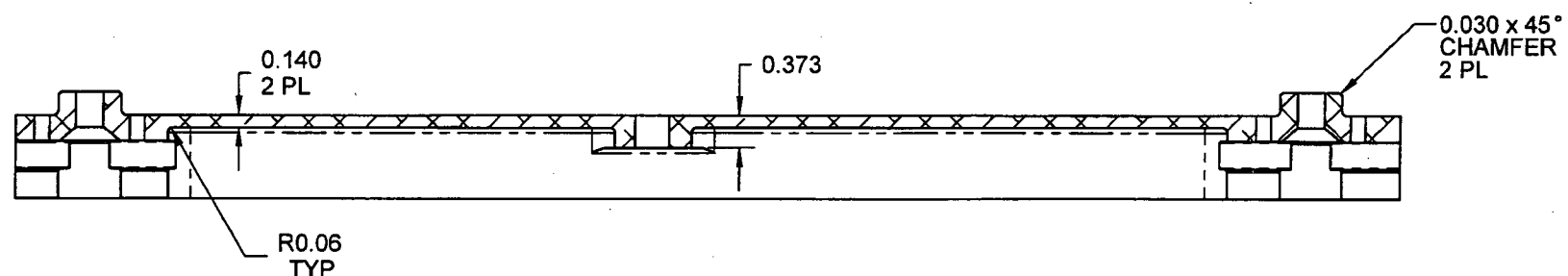
SHOP COPY
RETURN TO
ENGINEERING
RELEASED UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44178

A	NEW ISSUE	RF	08.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3808	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SEAT RAIL ASSEMBLY	NTS
DATE	08.08.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



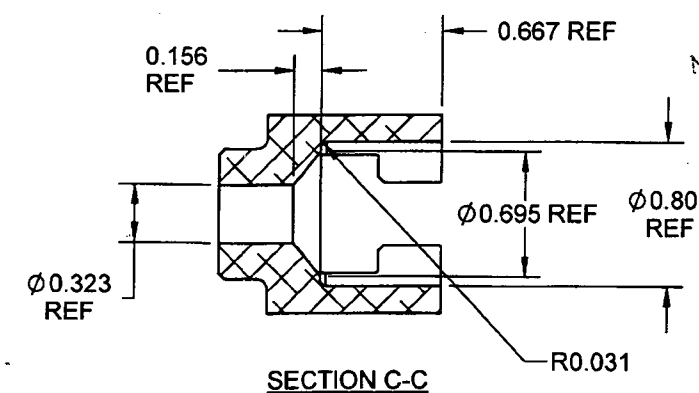


DETAIL VIEW B



SECTION A-A

D3808-1 SEAT RAIL



SECTION C-C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 00178

RELEASED
08-08-08

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE ARROW & FWD AS SHOWN USING 0.30 HIGH LETTERS TO MAX DEPTH OF 0.005
- 7) WEIGHT: 0.768 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3808	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SEAT RAIL ASSEMBLY	NTS
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